

Work Order ID 65992

February 1, 2011 7:35:10 AM



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Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Assembly					
Start Date:	2/01/11	Start Qty:	20.00		Cust Item ID:	
Required Date:	2/14/11	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/02/01</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100	BAND SAW	0.00							
	Bandsaw	0.00				<u>20</u>	<u>0</u>		
Jeaspa Bandsaw	Memo Cut blanks: 1.000" x 0.375" x 2.700" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00				<u>20</u>	<u>0</u>		
HAAS CNC vertical machine #1	Memo Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00				<u>20</u>	<u>0</u>		
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Required Date:	2/14/11	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>20</u>			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>20</u>	<u>6</u>	<u>11/03/02</u>	
180 Small Fab Small Fab	Small Fab Memo	0.00 0.00							
	1-Assemble as per Dwg D2873 <input type="checkbox"/> 2-Identify as D2873-045								

EP 11/03/03 (20)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D2873-045

Accept

Setup Start

Revision ID:

Stop

Item Name: Nut Plate Assembly

Start Date: 2/01/11 Start Qty: 20.00

Cust Item ID:

Required Date: 2/14/11 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 11 03 03 20

200

Identify as per dwg & Stock Location: x-tube Assy

0.00



Packaging

Memo

0.00

Packaging

ml 11 03 07 20

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/11 MK 11-03-07.

Picklist Print

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Work Order ID: 65992

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly



Start Date: 2/01/11

Required Date: 2/14/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	5.2367	0.225	4.736842			



6061T6 BAR .375 x 1.00

Location	Loc Qty	Loc Code
MAT01	0.45	
113325	0.45	
MAT04	4.7867	
114352	4.7867	

MS20426AD4-6 Purchased No



Rivet

Location	Loc Qty	Loc Code
ST317	1953	
110139	1953	

MS21075L5 Purchased No



Nut Plate

Location	Loc Qty	Loc Code
ST303	146	
116741	146	



4.74 *OK 11/02/25*



80 *ESU/03/03*



40 *ESU/03/03*

40

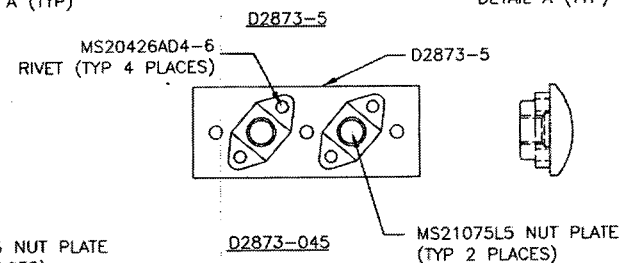
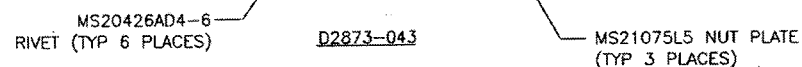
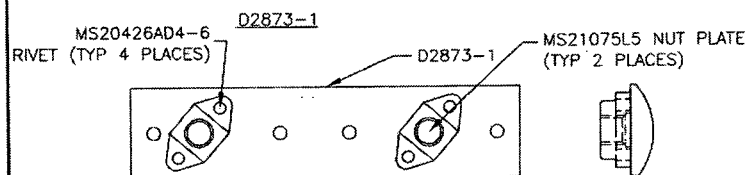
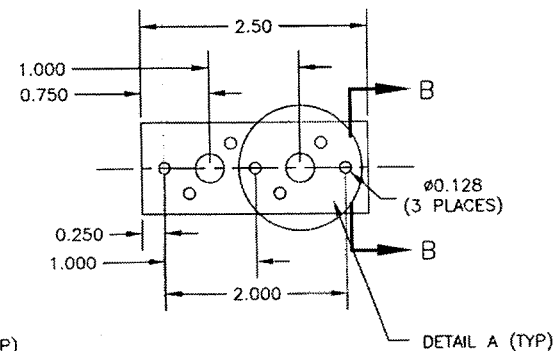
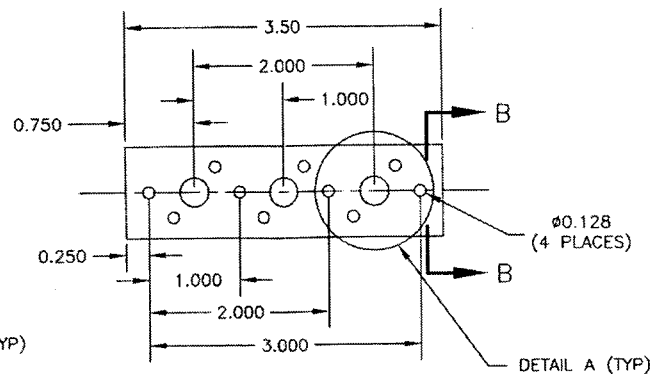
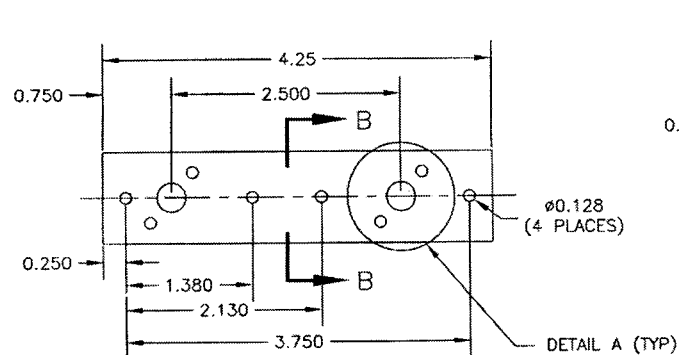
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D2873-1/-3/-5 RADIUS BLOCK

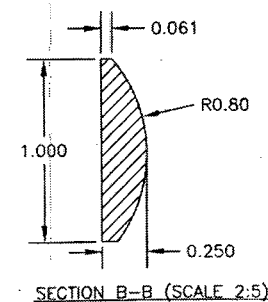
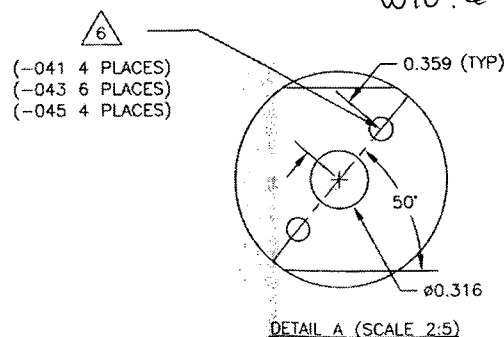
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
CHECKED <i>[Signature]</i> DS	APPROVED <i>[Signature]</i> DS	DRAWING NO. D2873 SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5

